

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017160**Date Inspected:** 17-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Geng Wei		
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** OBG Bike Path and Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 006693- Side A

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment Corner Assembly. The weld designations reviewed are as follows:

1. CA3016C-163~190
2. CA3016A-066~093
3. CA3015C-163~190
4. CA3015B-163~190

Ultrasonic Testing (UT) – NWIT Document No: 006695

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike path at Bay 19. The weld designations reviewed are as follows:

1. BK004A5-004-121

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### Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 067876 perform Flux Core Arc Welding (FCAW) Welding on the K-plate of OBG Segment 13AE, weld joint identified as KP3001-001- 003 and 007. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform FCAW Welding on the K-plate of OBG Segment 13AE, weld joint identified as KP3002-001-002. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

### OBG Segment 12AW

This QA inspector observed ZPMC qualified welding personnel identified as 045246 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 12AW, weld joint identified as OBE12G-009 and 010. ZPMC QC is identified as Mr. Wu Shi Gao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

### Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062738 perform FCAW on Bike Path, weld joint identified as BK004A3-014-051. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform FCAW on Bike Path, weld joint identified as BK004A4-014-040 and 041. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW on Bike Path, weld joint identified as BK004A6-010-070 and 078. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 208633 perform FCAW on Bike Path, weld joint identified as BK004A8-010-070 and 078. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 208633 perform FCAW on Bike Path, weld joint identified as BK004A2-016 and 018. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-

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B-T-2231-B-L1b-F-1.

Visual Inspection after Blast

Segment 11BE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11BE, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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